

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 82.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023242**Date Inspected:** 28-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Westmont Industries**Location:** Santa Fe Springs, CA**CWI Name:** Ruben Dominguez**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006 L & R**Component:** Maintenance Travelers**Summary of Items Observed:**

On this date, Caltrans Quality Assurance Inspector (QA) Sherri Brannon is present at the Westmont Industries (WMI) jobsite in Santa Fe Springs, California for the purpose of observing fabrication and QC functions for the SAS Superstructure, Bid Item # 99, Maintenance Traveler and Bid Item #100, Maintenance Traveler (Bike Path).

Traveler Test Rack

This QA Inspector observed no WMI production personnel performing fitting, welding or cutting activities on assemblies for the Traveler Test Rack.

Traveler's Trolley Train Assembly

This QA Inspector randomly observed WMI production welder Mr. Jose Rodriguez (WID # 3031) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Rodriguez performing the FCAW in all positions randomly throughout the shift.

This QA Inspector randomly observed WMI production welder Mr. Juan Lopez (WID # 3126) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in 2F horizontal position randomly throughout the shift.

This QA Inspector observed WMI production welder Mr. Charles Newton (WID # 3200) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Newton performing the FCAW in 2F horizontal position randomly throughout the shift.

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This QA Inspector observed WMI production welder Mr. Arturo Montes (WID # 3151) continuing to perform Flux Core Arc Welding (FCAW) activities on the trolley train assemblies. This QA Inspector observed Mr. Montes performing the FCAW in 2F horizontal position randomly throughout the shift.

SAS-WB Traveler – Lower Truss Frame Assembly

This QA Inspector randomly observed WMI production welder Mr. Eutimo Lopez (WID # 3035) continuing to perform Flux Core Arc Welding (FCAW) activities on the SAS-WB Traveler Lower Truss Frame Assemblies. This QA Inspector observed Mr. Lopez performing the FCAW in all positions on tube steel and plate material, randomly throughout the shift.

SAS-WB Traveler – Fixed Stairs Frame Assembly

This QA Inspector observed WMI production welder Mr. Daniel Grayum (WID # 3049) continuing to perform Flux Core Arc Welding (FCAW) activities on the Fix Stair Section Assemblies. This QA Inspector observed Mr. Grayum performing the FCAW in all positions randomly throughout the shift.

This QA Inspector observed WMI production personnel Mr. Cesar Canales and Mr. Raymundo Anaya performing layout and fitting activities at various locations for the SAS-WB Traveler Assemblies.

This QA Inspector randomly observed that Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez was present, during the above mentioned welding and fitting activities. During random observation, this QA Inspector observed that the applicable WPS's and copies of the shop drawings, appeared to be located near each work station, where the above mentioned welding and fitting activities were being performed. This QA Inspector randomly verified that the consumable material, utilized during the welding appeared to be in compliance with the applicable WPS and that the above mentioned welders were currently qualified for the applicable process and position of welding. This QA Inspector randomly observed QC Inspector Dominguez verifying the in-process welding parameters, including voltage, amperage, pre-heat and travel speed and the parameters appeared to be in compliance to the applicable WPS.

Paint: E2/E3-EB Travelers

This QA Inspector randomly observed that RPI personnel performing sweep blasting activities on the E2/E3-EB Travelers assemblies. After the sweep blast was complete QA Inspector then observed RPI Coating Quality Control Representative Mr. Andrew Gonzales performing what appeared to be random surface profile checks on the sweep blasted base metal surfaces. This QA Inspector observed Mr. Gonzales utilizing what appeared to be Testex Press-O-Film and a micrometer to perform the testing. Initially, this QA Inspector observed Mr. Gonzales applying the film to the blasted surface then utilizes one end of a pen to perform rubbing activities on the clear portion of the test strip. This QA Inspector then observed Mr. Gonzales utilize a micrometer to measure the surface profile on the clear film part of the strip, in which the rubbing was performed. Mr. Gonzales explained to this QA Inspector that the initial setting on the micrometer was set at 2mils over, due to the thickness of the X-Coarse Press-O-Film paper. During observation, this QA Inspector observed that the readings appeared to be 2.5 mils, 2.2 mils, 2.6 mils, 2.8 mils, and 2.3 mils. This QA Inspector noted that the contract requires a surface profile of 1.57 mils, (40 um) - 3.15mils (80um) and that the above mentioned tested profile appears to be in compliance with the contract requirements. After surface profile testing, this QA Inspector then observed Mr. Torres perform a test for soluble salts on the previously blasted base metal areas. This QA Inspector observed the testing being performed at random areas which appeared to meet or exceed one test per 200 square meters, per the

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contract requirements. After testing, this QA Inspector observed that the soluble salt content appeared not exceed the 10 micrograms per square centimeter. QA also, performed randomly visual inspection on the E2/E3-EB Traveler and noted 3 areas that had been opened up after blasting had been completed. The 3 areas were taped off for in process welding to be completed later. QA Inspector informed QA Lead Inspector Mr. Joe Lanz and WMI – Production Manger Mr. Brad Petrie and Shop Superintendent Mr. George Grayum and Smith Emery, CWI, QC Inspector Mr. Ruben Dominguez. This QA Inspector was then informed by Mr. Torres that primer application will start within the next hour.

E2/E3 BIKE PATH TRAVELER

This QA Inspector randomly observed WMI personnel cutting material to be used in the Bike Path Traveler.

This QA Inspector observed that the activities mentioned above, appeared to be in compliance with the contract requirements and this QA Inspector observed no non-conforming issues, on this date.



Summary of Conversations:

As noted within this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Brannon, Sherri	Quality Assurance Inspector
Reviewed By:	Lanz, Joe	QA Reviewer
